

Date: Wednesday, 20/08/2008 1:51:26 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TURNING DETAIL FOR D2940-1
Job Number	: 41529		
Estimate Number	: 13237		
P.O. Number	:	Part Number	: DSK081
This Issue	: 20/08/2008 S.O. No. :	Drawing Number	: DSK081 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 40801	Material	:
Written By	:	Due Date	: 29/08/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JUL 08.8.20</u>		
Comment	: est rev A. 08.03.13 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6104007	Round Billet, 17-4
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Billet

BATCH:

B41967

J.F. 08/10/01

(10)

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: ~~MORI SEIKI CNC LATHE LARGE~~

Turn blank as per Folio FA079

Doosan

J.F. 08/10/01

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/10/01

(10)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5 OF 10
 DIP 08/10/02
 24 08/10/04 10/10

(10)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock in Kanban

Location:

CNC

J.F. 08/10/04

(10)

6.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/10/08

Job Completion



MF 08-10-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 41529
Description: Turning Detail for D2940-1		Part Number: DSK081
Inspection Dwg: DSK081	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.211	3.216		3.214"	3.215"	3.214"	3.215"	3.212"
B	4.946	4.966		4.958"	4.957"	4.958"	4.958"	4.959"
C	0.718	0.738		.730"	.730"	.730"	.730"	.730"
D	0.090	0.110		.100"	.100"	.099"	.099"	.101"
E	3.564	3.584		3.578"	3.577"	3.576"	3.576"	3.575"
F	0.022	0.042		.032"	.032"	.032"	.032"	.032"
G	3.444	3.464		3.457"	3.456"	3.457"	3.456"	3.456"
H	0.112	0.132		.122"	.120"	.122"	.121"	.123"
I	2.170	2.190		2.180"	2.180"	2.180"	2.180"	2.180"
J	4.451	4.471		4.463"	4.463"	4.463"	4.462"	4.460"
K	0.413	0.433		.423"	.423"	.423"	.423"	.423"
L	0.913	0.933		.933"	.928"	.928"	.928"	.928"
M								
N								
O								
P								

Measured by: J.F. Date: 08/10/01

Audited by: DTP Date: 08/10/02

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order: 241529
Description: Turning Detail for D2940-1		Part Number: DSK081
Inspection Dwg: DSK081	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
Lathe Section								
A	3.211	3.216		3.214"	3.214"	3.213"	3.215"	3.213"
B	4.946	4.966		4.957"	4.958"	4.958"	4.959"	4.958"
C	0.718	0.738		.730"	.730"	.728"	.728"	.730"
D	0.090	0.110		.099"	.099"	.099"	.100"	.098"
E	3.564	3.584		3.576"	3.574"	3.575"	3.575"	3.575"
F	0.022	0.042		.032"	.032"	.032"	.032"	.032"
G	3.444	3.464		3.456"	3.453"	3.453"	3.453"	3.453"
H	0.112	0.132		.122"	.121"	.121"	.122"	.120"
I	2.170	2.190		2.180"	2.180"	2.180"	2.180"	2.180"
J	4.451	4.471		4.464"	4.460"	4.461"	4.460"	4.461"
K	0.413	0.433		.423"	.423"	.423"	.423"	.423"
L	0.913	0.933		.933"	.933"	.933"	.933"	.933"
M								
N								
O								
P								

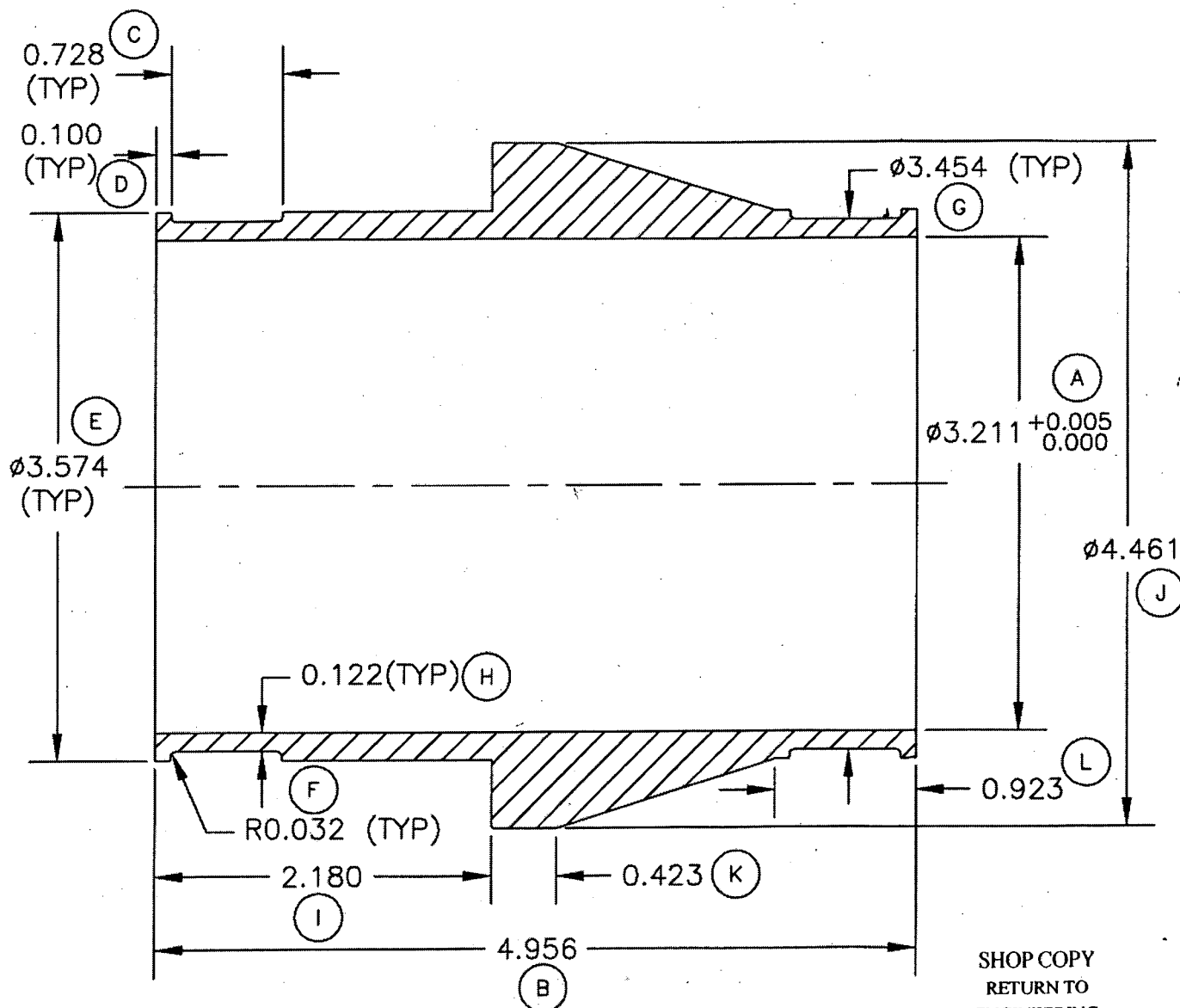
Measured by: J.F.	Date: 08/10/04
Audited by: [Signature]	Date: 08/14/04
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	[Signature]



DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 081	REV. B SHEET 1 OF 1
DATE 03.06.24		TITLE TURNING DETAIL FOR D2940-1	SCALE 1:1
A	03.03.07	NEW ISSUE	
B	03.06.24	ADDED 4.956 DIMENSION	

RELEASED
03.07.01 [Signature]



D2940-1 TURNING DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41529

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